



Dart Aerospace Ltd.
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RBT400213-7
Job Sheet 189142



Part No: RBT400213-7

Job Qty: 20 pcs

Part Name: Top Tab Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400213 Rev F IPP Rev A 17.11.27 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. F DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Small Fab - 1	20 pcs	2/22/19		0.00	20.00	Small Fab - 1	MLL
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
120	QC 5	20 pcs	2/22/19		0.00	0.00	QC 5 - 10	AUG 1 2 2019
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
130	Packaging 3-1 - Stock - B4B	20 pcs	2/22/19		0.00	0.00	Packaging 3 - 1 - B4B	DAS 40 9-89
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	



Container No: S202545



Part: RBT400213-7

Job No: 189142

Serial No/Batch: S202545

Revision: F

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 08/02/19

Plex 1/18/19 2:23 PM Dart.lajeunesse.marie

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	20 pcs	2/22/19	0.00 0.00	QC 21 - SA - 21	GA136
					QC 21 - SA - 70	AUG 13 2019

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 6 --LOCTITE CLEAR EPOXY M 5152077 EXP: 8/20/20
 Descriptions: Cure time 8Hrs. Start Time: Finish Time: 12:00 pm next day
 120 - (QC5- Inspect part completeness to step on W/O) → 9:00am 8/2/19
 130 - (Identify as per dwg & Stock Location:)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-10A	Bolt	80 Ea (4 ea)	110-Small Fab - 1	38X5162658 42X5149562
RBT400213-3	Left Clamp	20 pcs (1 ea)	110-Small Fab - 1	5191761
RBT400213-4	Right Clamp	20 pcs (1 ea)	110-Small Fab - 1	17X5192031 3X5107540
RBT400213-5	Top Tab	20 pcs (1 ea)	110-Small Fab - 1	5194818
MS20426AD4-8	Rivet	80 Ea (4 ea)	110-Small Fab - 1	51181136-4

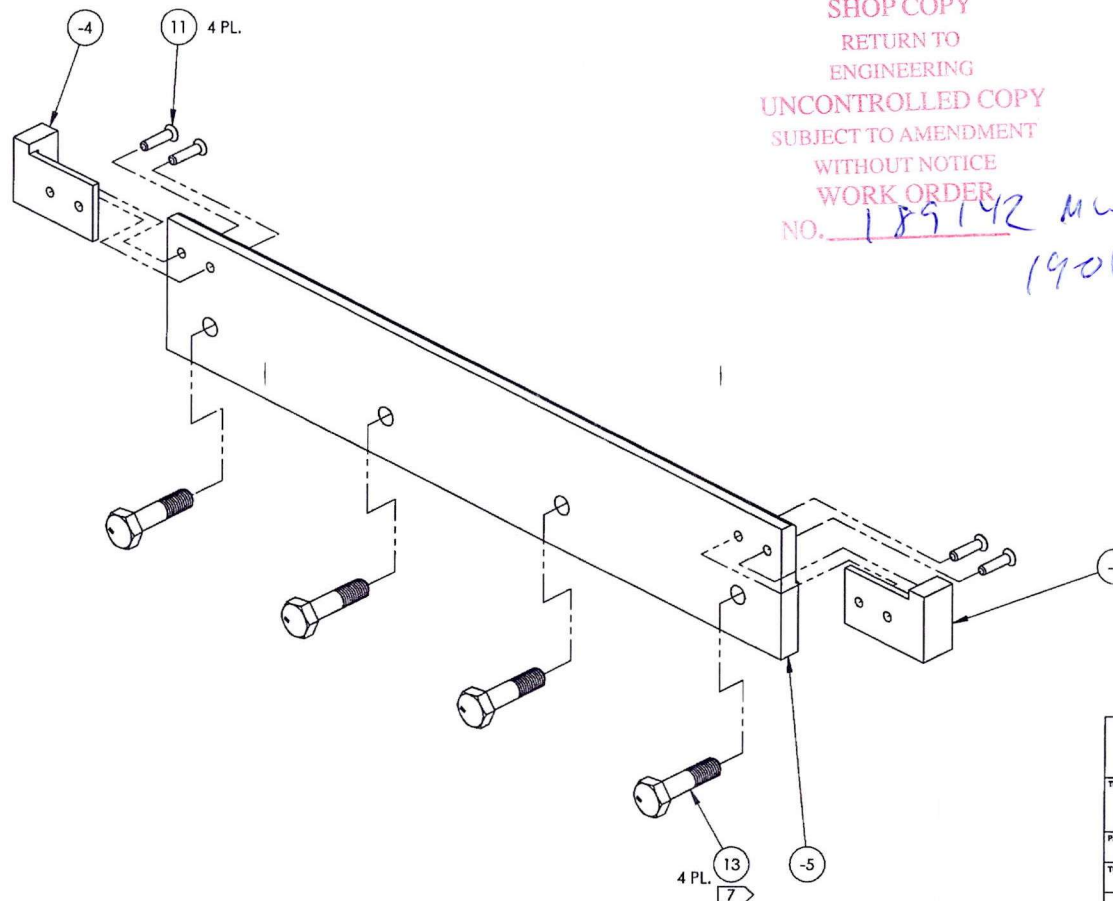
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN4-10A	80	138	0
	MS20426AD4-8	80	2,743	0
	RBT400213-3	20	4	0
	RBT400213-4	20	5	0
	RBT400213-5	20	0	0

Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-3	1	RBT400213-3	LEFT CLAMP	4	F	TEMPLATE UPDATED, EPOXY CHANGED FOR EPOXY DP460	17-797	17.12.21	VM	ML
-4	1	RBT400213-4	RIGHT CLAMP	5						
-5	1	RBT400213-5	TOP TAB	6						
11	4	AN426AD-4-8	C.S HEAD RIVET 1/8" x 1/2" x 100"	-						
13	4	AN4-10A	HEX HEAD BOLT 1/4"-28 x 1 1/32"	-						



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189142 ML5
1901-21

RBT400213-7 TOP TAB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) APPLY SCOTCH WELD DP460 EPOXY UNDER BOLT HEAD AND INSTALL BOLT INTO ITEM -5. ALLOW TO CURE PER MANUFACTURER'S INSTRUCTIONS

DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE TOP TAB ASSY			
PART NO. RBT400213-7		REV F	
TOOL NO. RBT400213		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 12/21/2017	INITIALS AND DATE	TOLERANCES: XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS
DRAWN BY: VM 01/02/2018			
CHECKED BY: VM 01/02/2018			
MFG REVIEW BY: DD 01/02/2018			
APPROVED BY: ML 01/30/2018		SCALE: NTS	SHEET 3 OF 7
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